

**Work Order ID 72324**

Friday, July 22, 2011 11:23:37 AM



Page 1

Item ID: D4306-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, LH

Start Date: 7/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-07-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch: M117884 0.00



Large Fab

Memo

0.00

Pl 11-09-08 (2)

Large Fab

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size and cut notch as per dwg D4306-3

4- Drill and chamfer holes as per dwg D4306-3 using DT9710

SAD 11-09-08

5- weld bushing as per dwg D4306

6- grind welds flush

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8 4/02/09

(2)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 72324




Friday, July 22, 2011 11:23:37 AM



Page 2

Item ID: D4306-043 Accept  Setup Start   
Revision ID: Stop   
Item Name: Rib Assembly, LH  
Start Date: 7/22/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 7/29/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QSI004- ground welds <i>QC9</i> Memo	0.00 0.00				<i>2</i>	<i>0</i>	<i>11/09/08</i>	
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>W00A6</i> Memo	0.00 0.00							<i>EL / PMB 11/09/12 (2)</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/9/13</i>

*MF*  
*11-09-13*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 22, 2011 11:23:42 AM

Page 1

Work Order ID: 72324

Parent Item: D4306-043

Parent Item Name: Rib Assembly, LH



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC  
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Manufactured No

100

Each

137.0000

4

8



Bushing

Location

Loc Qty

Loc Code

WA

135

69202

135

WA005

2

66489

2

M304TS0.750W.049

Purchased

No

100

f

285.0645

4.166

8.770526



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

108.325209

117690

4.372109

117775

103.9531

MAT034

7.5904

117337

7.5904

WA

169.14894

118184

169.14894

M118472

8.7706

CP 11.09.08

8

SAD 11-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

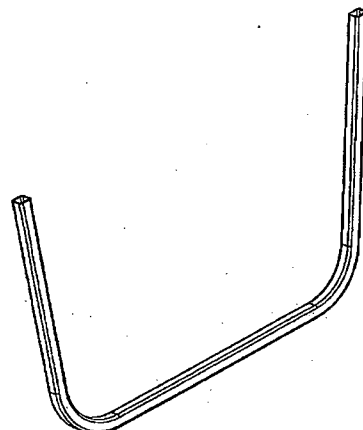
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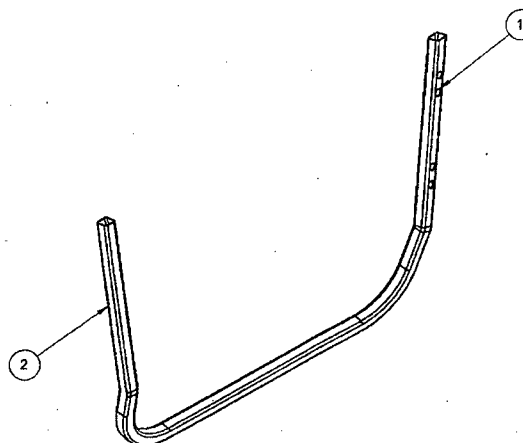
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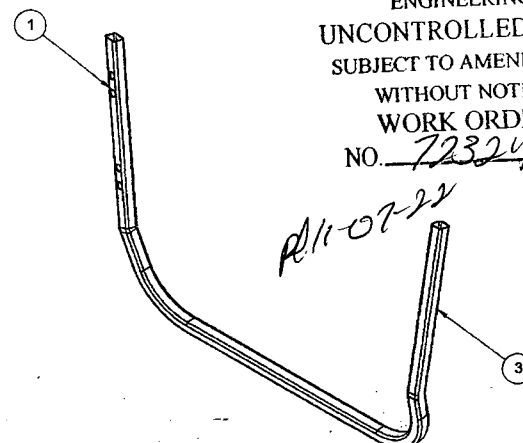
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



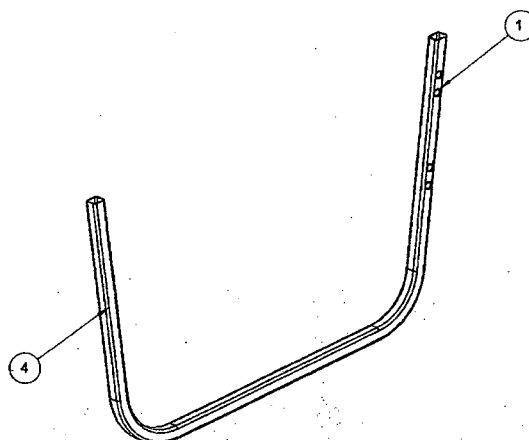
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**



**D4306-045 RIB ASSY**

SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72324

*R11-07-22*

**RELEASED**  
2011-03-18

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4306</b>	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB</b>	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED, OR COMPILED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

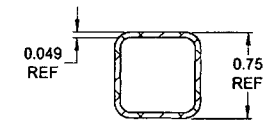
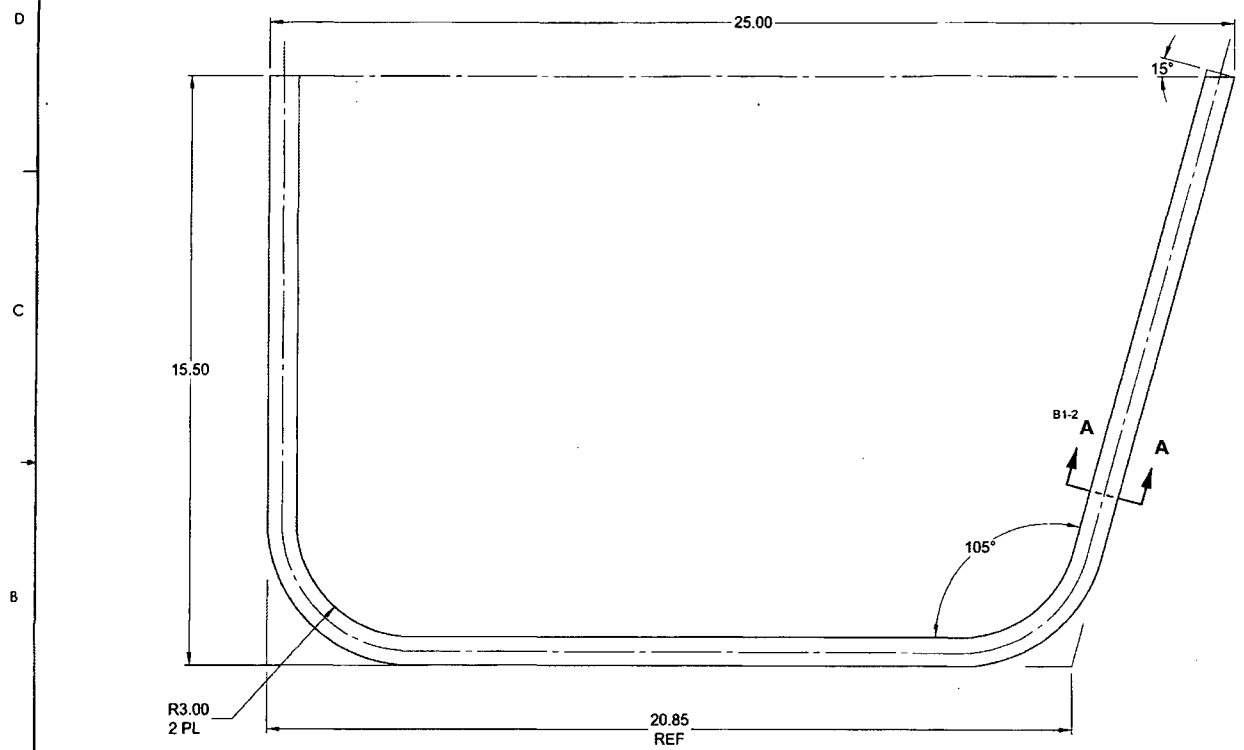
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



SECTION A-A B4-2

8 D4306-1 RIB

12324

RELEASED  
2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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MFG. APPR.		D4306	SHEET 2 OF 8
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8 7 6 5 4 3 2 1

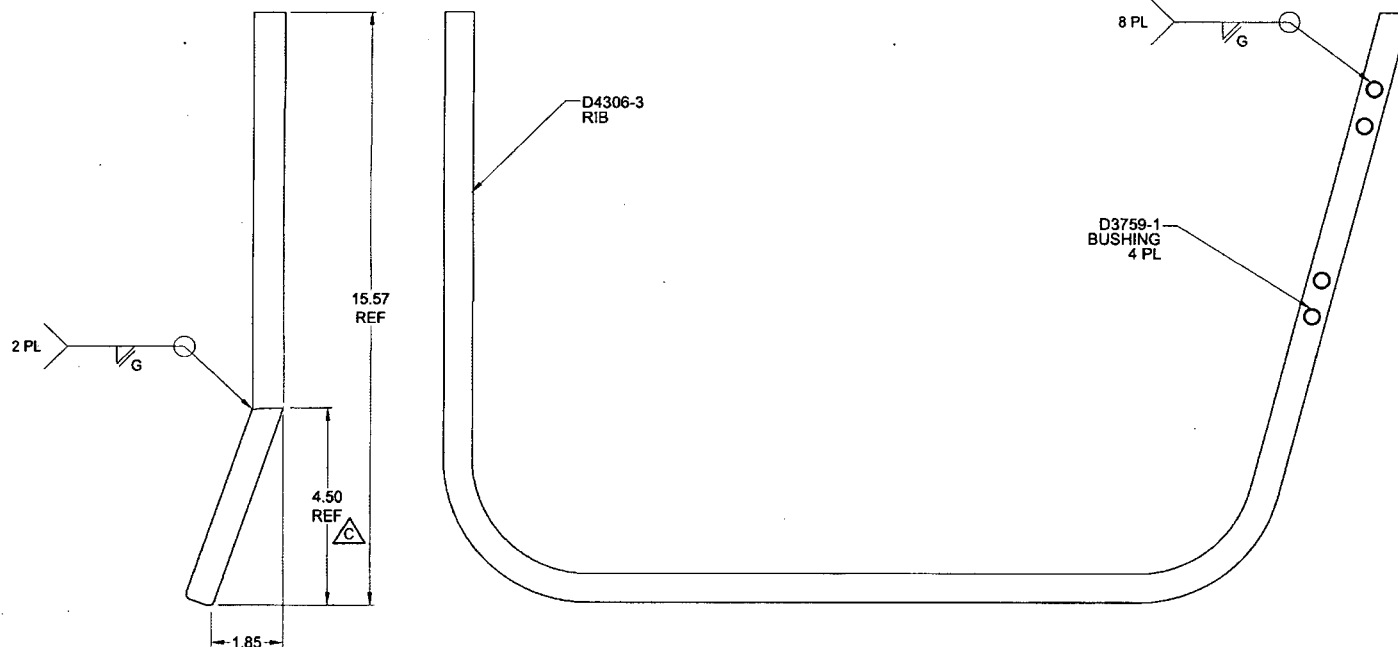
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**NOTE:** Date & initial all entries



**D4306-043 RIB ASSY, LH**

**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

72324

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D4306</b>	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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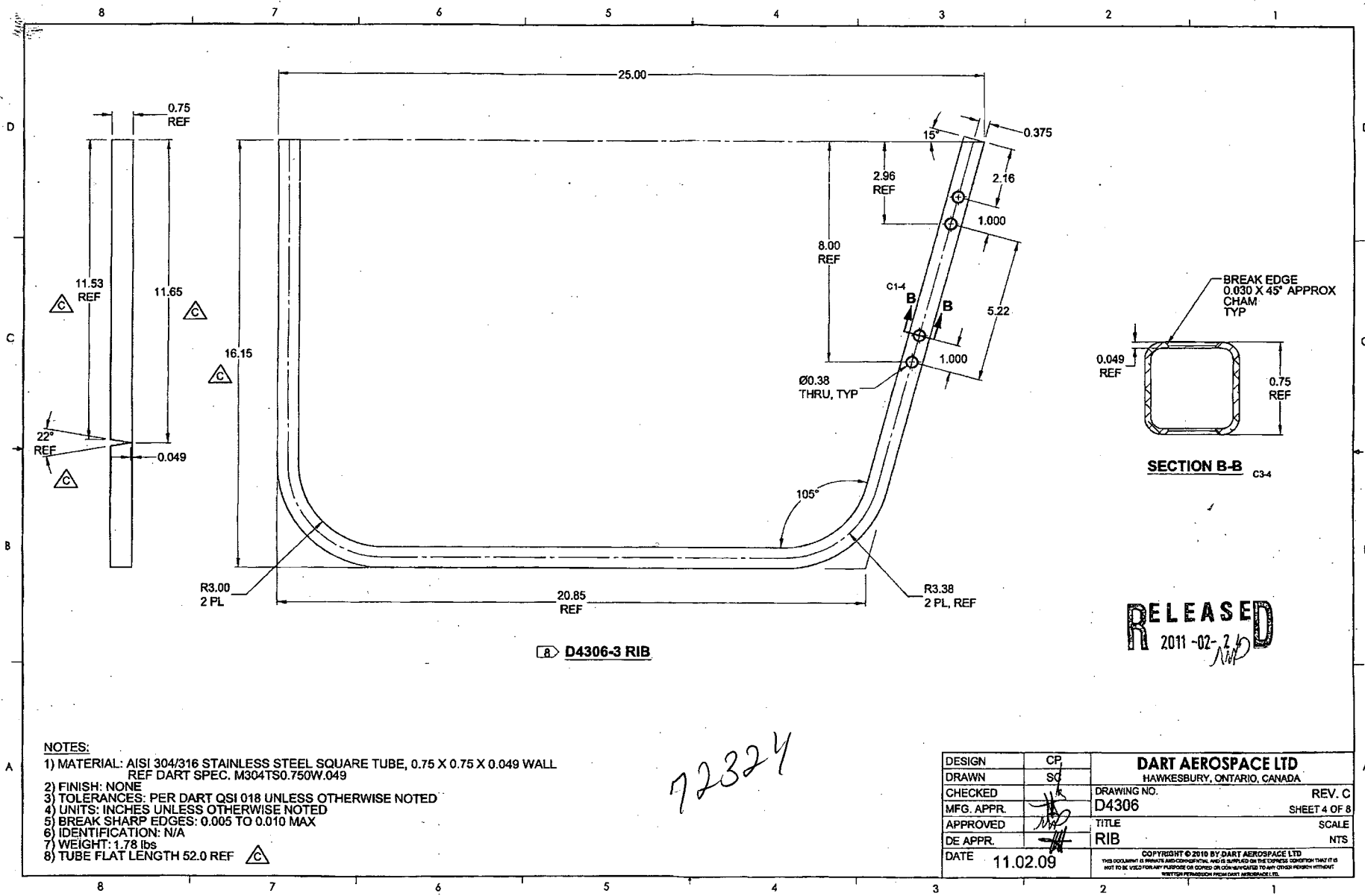
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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

72324

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
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MFG. APPR.		D4306	SHEET 4 OF 8
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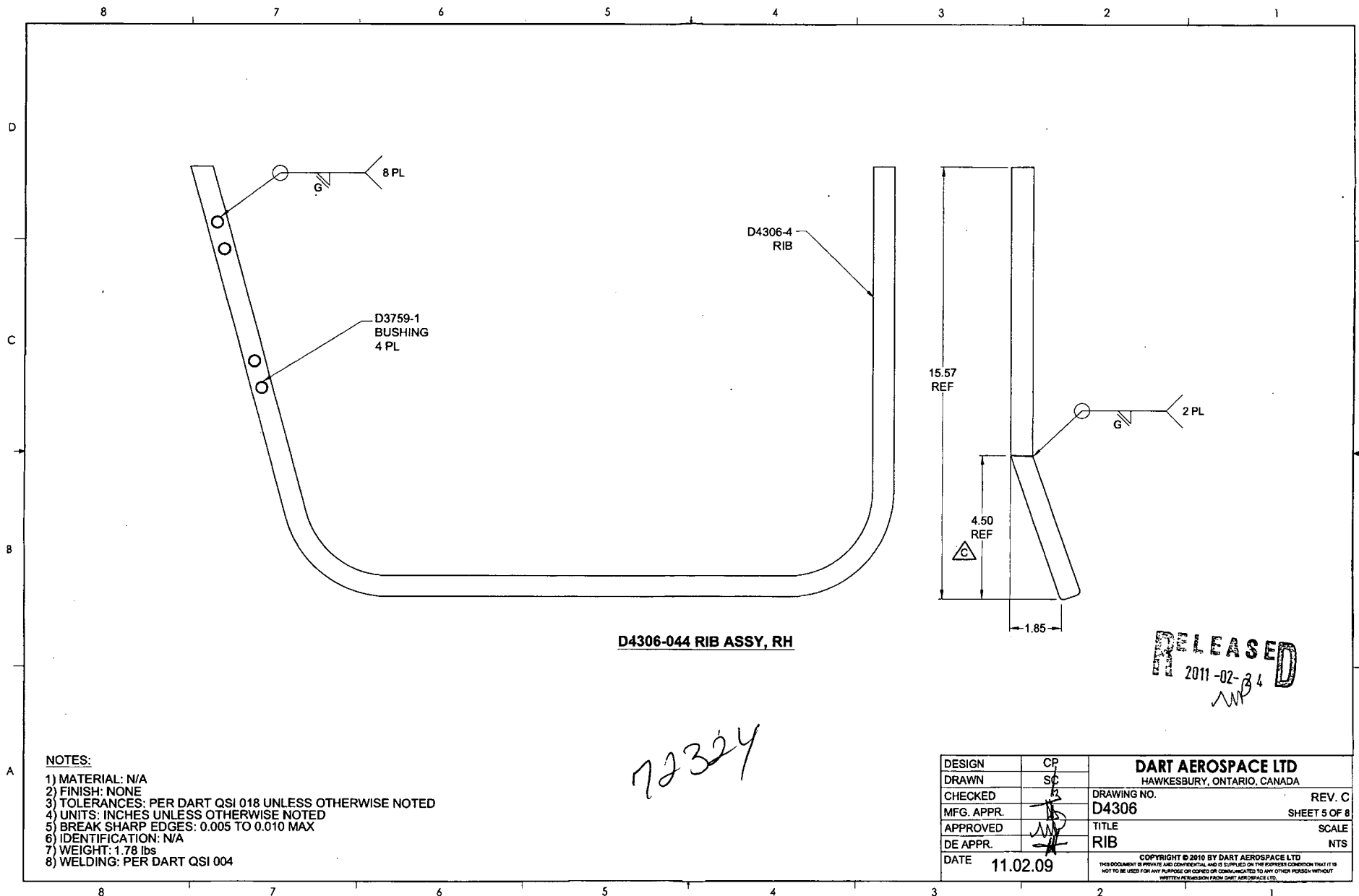
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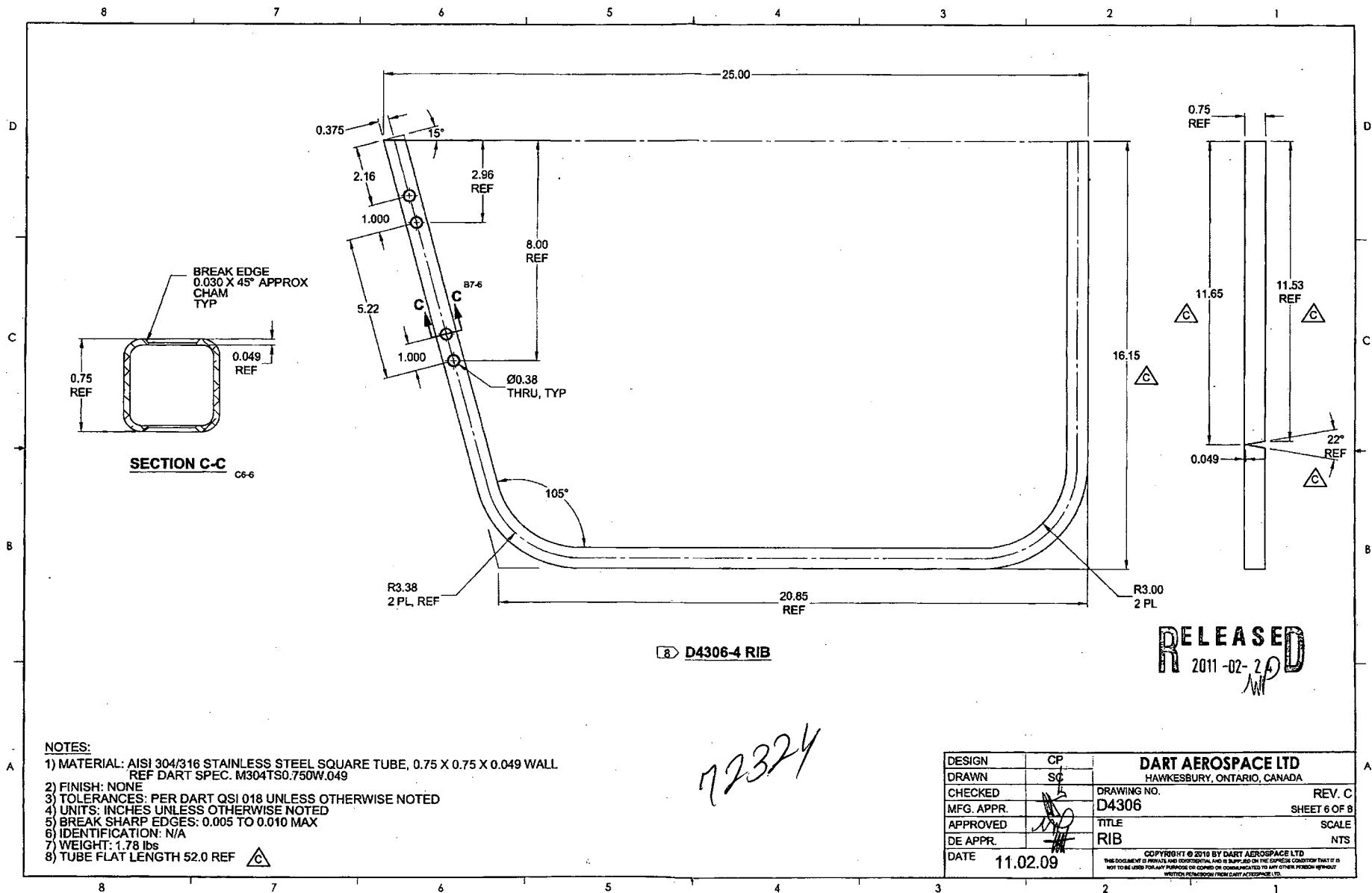
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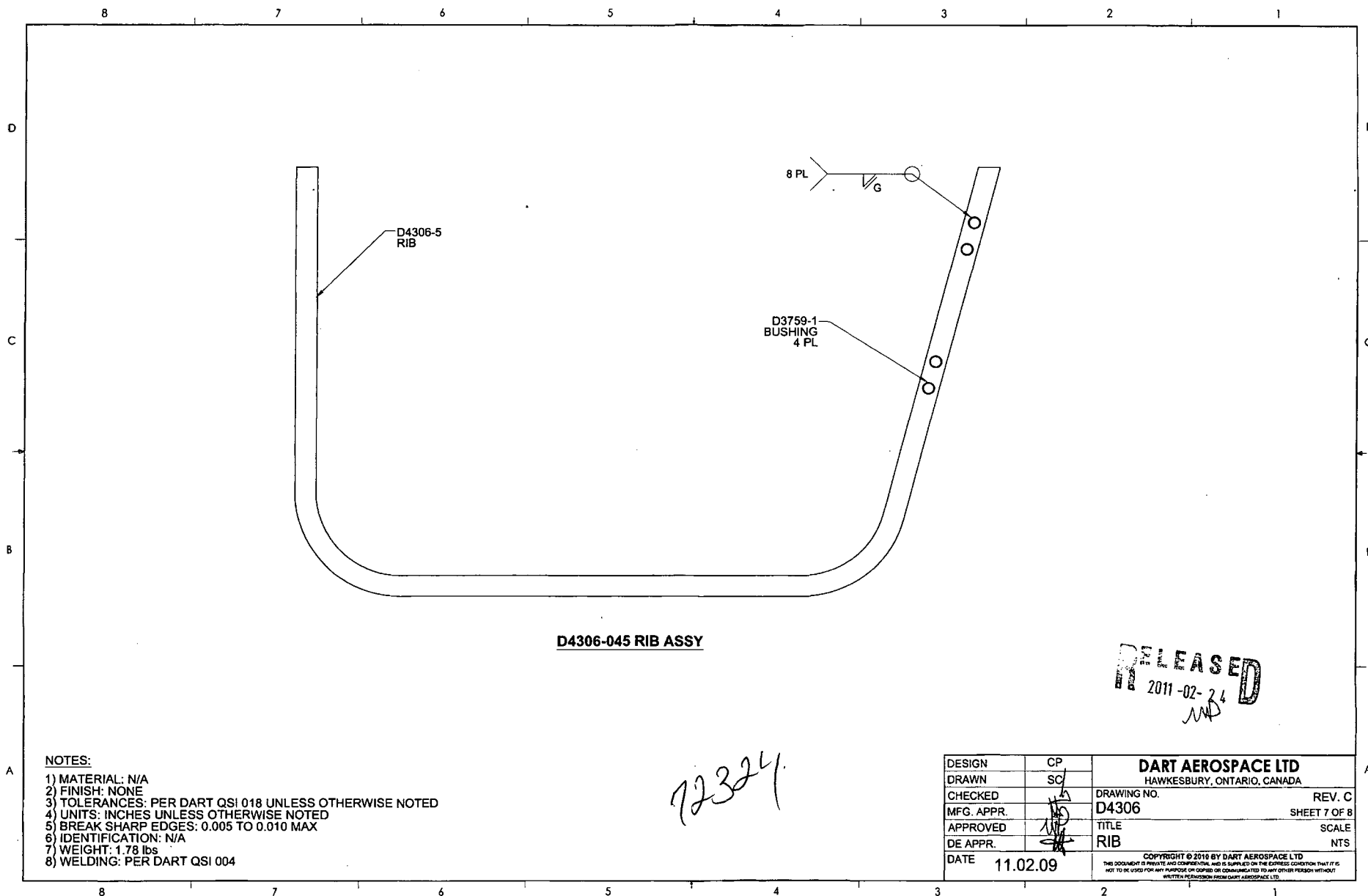
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